

Work Order ID 65615

January 20, 2011 11:14:08 AM



Page 1

Item ID: D4061-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Ski Cushion

Start Date: 1/20/11 Start Qty: 8.00



Cust Item ID:

Required Date: 1/27/11 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 11/01/20 Tooling:

Date:

Run Start



QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4061	B
-------	---

100

0.00



Mill Conv

Memo

0.00

Conventional Milling Machine

1-Turn as per folio FA914 & dwg

FOLIO REV: _____

DWG REV: _____

2-Debur as required

11/02/01

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11/02/02

Work Order ID 65615

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Item ID:	D4061-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Ski Cushion					
Start Date:	1/20/11	Start Qty: 8.00		Cust Item ID:		
Required Date:	1/27/11	Req'd Qty: 8.00		Customer:		
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC8- Inspect parts - second check	0.00				8			
QC Quality Control	Memo	0.00							
130 	Identify as per dwg & Stock Location: <u>1A1</u>	0.00							
Packaging Packaging	Memo	0.00							
140 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

11.2.2

11/24/11

11/02/03

MF 11-02-03

Picklist Print

January 20, 2011 11:14:07 AM

Page 1

Work Order ID: 65615

Parent Item: D4061-1

Parent Item Name: Ski Cushion



Start Date: 1/20/11

Required Date: 1/27/11

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE JLM 10-02-18 VERIFIED BY:EC IPP
REV:B 11.01.10 AS PER DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-3		Manufactured	No			1001	f	15.6000	0.4125	3.473684			



UHMW U-Channel



Location

Loc Qty

Loc Code

ST

15.6

63829

15.6

3.6

11/02/01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

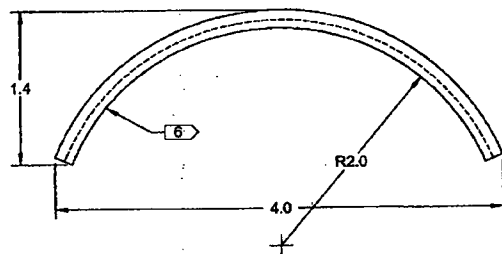
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

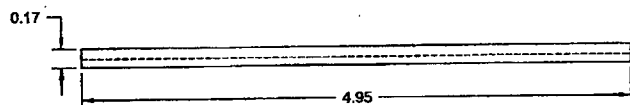
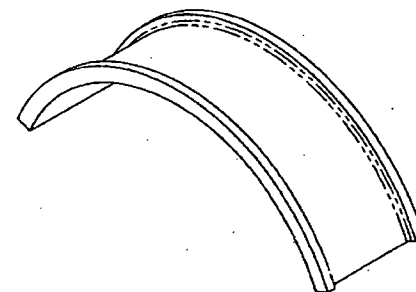
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65615

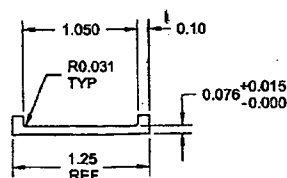
C211/0120



D4061-1 412 SKI CUSHION
(MAKE FROM D4061-1F)



D4061-1F FLAT MACHINED STATE



RELEASED
2010-12-23
MB

NOTES:

- 1) MATERIAL: MAKE FROM D4287-3
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4061-1" AND B/N "BXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs

B	CHANGED RAW MATERIAL TO REDUCE MANUFACTURING COSTS. PART NOW MACHINED FLAT AND SHAPED WITH ADEQUATE RADIUS. REF: PAR10-29.	MB	10.12.07
A	NEW ISSUE	MB	10.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.07		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4061** REV. B
SHEET 1 OF 1
TITLE **412 SKI CUSHION** SCALE NTS

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Work Order ID 63829

November 15, 2010 2:24:13 PM



Page 1

Item ID: D4287-3

Accept



Setup Start



Revision ID:

Item Name: UHMW U-Channel

Stop



Start Date: 11/15/10 Start Qty: 16.00

ff



Required Date: 11/17/10 Req'd Qty: 16.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

W

Date:

Tooling:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D4287

A

100

0.00



Purchasing

Memo

0.00

Purchasing

Issue P/O: 12924
Material: UHMW (white)
Supplier P#: McMaster-Carr 8672K31
Material release note required

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Solulis

CL 10/11/15 16

10/14/17 (16)

+2
length p 8'
= 16'

Work Order ID 63829

November 15, 2010 2:24:14 PM

Page 2

Item ID: D4287-3

Accept

Setup Start

Revision ID:

Stop

Item Name: UHMW U-Channel

Start Date: 11/15/10 Start Qty: 16.00

Required Date: 11/17/10 Req'd Qty: 16.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

10/11/18

140

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/18

ME 10-11-18

Picklist Print

November 15, 2010 2:24:12 PM

Page 1

Work Order ID: 63829

Parent Item: D4287-3

Parent Item Name: UHMW U-Channel



Start Date: 11/15/10

Required Date: 11/17/10

Start Qty: 16.00

Required Qty: 16.00

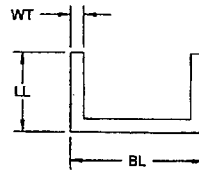
Comments: IPP Rev:A 10.11.15 new issue DD Verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
8672K31		Purchased	No			110	f	0.0000	1	16			
UHMW U-Channel													



Rec'd 11/17/10

SPECIFICATION CONTROL DRAWING



D4287-X UHMW U-CHANNEL

DART PART NUMBER	POSSIBLE SUPPLIER	SUPPLIER PART NUMBER	MATERIAL	PURCHASED LENGTH	BASE LENGTH (BL)	LEG LENGTH (LL)	WALL THICKNESS (WT)	WEIGHT (lbs)
D4287-1	McMASTER-CARR	8928K53	UHMW (WHITE)	96.0	1.05	0.75	0.250	2.11
D4287-3	McMASTER-CARR	8672K31	UHMW (WHITE)	96.0	1.25	0.75	0.125	1.29

RELEASED
2010-11-03

NOTES:

- 1) MATERIAL: PURCHASE PER TABLE
OR
UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
REF. DART SPEC. MUHMW
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: PER TABLE

A	NEW ISSUE	MB	10.10.26
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.10.26		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **DSC-D4287** REV. A
TITLE **UHMW U-CHANNEL** SCALE NTS

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO12924

Purchase Order Date 11/15/10
PO Print Date 11/15/10

Page Number 1 of 2

Order From :
MCMASTER-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	330 995 5500	Requisition Nbr	
Vendor Fax	330 995 9600	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	USD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED
Ex 10/11/10

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	9928K53	UHMW U-Channel	11/17/10 Yes	16.00 f	Purolator ground	\$2.2800	\$36.48
		Special Inst:	AS PER DWG D4287 REV. A B63828 MCMASTER P/N: 9928K53				
2	8672K31	UHMW U-Channel	11/17/10 Yes	16.00 f	Purolator ground	\$2.2700	\$36.32
		Special Inst:	AS PER DWG D4287 REV. A B63829 MCMASTER P/N: 8672K31				
3		96006A646 BOLT	11/17/10 Yes	✓ 4.00	Purolator ground	\$10.3600	\$41.44
Deliver To: ERIC.L							
4		13335T37 YELLOW INK	11/17/10 No	1.00	Purolator ground	\$10.2800	\$10.28

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 11/15/10

McMASTER-CARR®

200 Aurora Industrial Parkway
Aurora OH 44202
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO12924

Page 1 of 1

McMaster-Carr Number
8530900-01

11/15/2010

Line	Description	Ordered	Shipped
1	9928K53 UHMW Polyethylene U-Channel, 1" Base X 3/4" Legs, 1/4" Thick	16 Feet	16
	Unit Price:	\$2.28	
	Extended Price:	\$36.48	
2	8672K31 Wear-Resistant UHMW Polyethylene Edge Trim, U-Shaped, 1-1/4" Base X 3/4" Legs	16 Feet	16
	Unit Price:	\$2.27	
	Extended Price:	\$36.32	

5 - 23 - 13 69 - 51 K53 16 FT 1

5 - 23 - 15 64 - 45 K31 16 FT 2

Charges for this shipment

Merchandise Amount \$72.80
Sales Tax: \$3.64
Total: \$76.44

8/10/1/18

Dart Aerospace Ltd

EXP

PL



7 lbs
2 lines

FW1BSP51
11/15/2010
14:22/14:52
048
Cycle 49

0132552975293



3 59-R-0707